User:

Monday, 02/03/2009 11:23:43 AM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number

: 46165

Estimate Number

: 10162

P.O. Number

This Issue : 02/03/2009

: NC Prsht Rev.

First Issue **Previous Run**

Written By

: // : 41433 Type

: SMALL /MED FAB

Part Number

Drawing Name

: D2587

Drawing Number

- D2587 REV A1 : N/A

Project Number Drawing Revision

: A1

Material **Due Date**

: 13/03/2009

: DOOR SLUG

Qty:

20 Um:

Each

Checked & Approved By

Comment

04.05.31 : Est D

Step 2 changed

Est E 06.07.31 Waterjet EC

KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6S040

6061-T6 .040 Sheet

Comment: Qty.:

0.0168 sf(s)/Unit

Total:

0.3360 sf(s)

6061T6 alum. sheet 0.040" thick Batch: _109058=

2.0

WATER JET

FLOW WATER JET



1-Cut as per Dwg D2587 Dwg Rev: H

Prog Rev: A

2-Deburr if necessary

INSPECT PARTS AS THEY COME OFF



3.0

QC2

SECOND CHECK



PARTS AS THEY COME OFF MACHINE **Comment: INSPECT**

4.0

QC8

5.03.10



5.0

HAND FINISHING

Comment: SECOND CHECK

HAND FINISHING RESOURCE #1





Acid etch and Alodine as per QSI 005 4.1



Comment: HAND FINISHING RESOURCE #1

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cated	orv:	NCR: Yes	No DO	Δ.	Date:	
		olution:							
NCR:				R NON-CONFORMA					
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign	Verific		Approval	Approval
		Section A	Chief Eng	Chief Eng	Date	Section Sectio	on C	Chief Eng	QC Inspector
		e							

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:23:43 AM User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: DOOR SLUG Job Number: 46165 Part Number: D2587 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 QC3 Comment: INSPECT ALODINE 09-7.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANG	ES				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	Resc	olution:	Disposition	1:	QA: N/C CI	osed:		Date:	
NCR:			WORK ORD	R NON-CONFORMA	NCE (NCF	R)	•		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign 8 Date	Verific Section	ation on C	Approval Chief Eng	Approval QC Inspector
				Ollio Eng	Dute				
			,						

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	46165
Description: Door Slug	Part Number:	D2587
Inspection Dwg: D2587 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	ıments
1.500	+/-0.010	1.493	1		vern		
0.040	+/-0.010	0.038	V		vern		
			, ,			<u> </u>	
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	_						
							<u> </u>
-	<u> </u>						
				9			
easured by:	m. M	Audited by:			Prototype Ap	proval:	N/A
Date:	9 03 10	Date:	psus.	10		Date:	N/A
ev Date	Change		/		Re	vised by	Approx

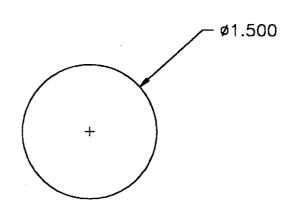
04.08.12 New Issue





DESIGN	DRAWN BY	DART AEROSPACE	LTD	
MIKE M	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, C	ANADA	
CHECKED	APPROVED	DRAWING NO.		REV. A
701.111.	M. M.	D2587	SHEET	1 OF 1
DATE		TITLE		SCALE
96:07:11		DOOR SLUG		1:1
AI KIM	03.09.16	ADD 6061-TG OPTION		

RELEASED



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WITHOUT NOTICE

WORK ORDER

OR 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)/AI

MATERIAL: 5052-H32, 0.040 THICK FINISH: ACID ECTCH, ALODINE